

Work Order ID 80708

February-27-12 2:55:41 PM

80708

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Item ID: D2563 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Weldment Assembly
 Start Date: 27/02/2012 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 12/03/2012 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/02/27 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2563	Rev C								
100	Large Fab	0.00				5	0		
100									
Large Fab	Memo	0.00							
Large Fab	1-Cut D2244 to 89.70" at 34 deg as per dwg D2563								
	2-Deburr ends								
	3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343								
	4- Grind								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00				5	0		
110									
QC	Memo	0.00							
Quality Control									

12.03.01

BE 12/03/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									

Sublog

45

5X Ø m-12/03/12

5 f 12/03/12

W/O:		WORK ORDER CHANGES					
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: <u>119785</u> Large Fab Memo 1-Inspect for foreign object per QSI 024 2-Weld Remaining End cap as per Dwg D2563 using DT 8343 3-Grind → <u>As 12.03.12</u>	0.00 0.00				<u>5</u>	<u>0</u>		
160 *160* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							<u>8/26/12</u>
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							<u>8/26/12</u> <u>Q</u>

W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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175 Pressure Wash per QSI005 4.3 0.00

175

HandFinish

Memo

0.00

Hand Finishing

Touch up Alodine as per QSI005

SX PM 12/03/14

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

180

Powdercoat

Memo

0.00

Powder Coating

Touch up Alodine then

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

8h30

OVEN TEMPERATURE:

320°F

FINISH TIME:

9h00

5 M 12/03/15

190

Wing Walk as per dwg QSI005 4.4 Batch *M120125* 0.00

190

HandFinish

Memo

0.00

Hand Finishing

SX PM 12/03/16

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200 QC3- Inspect Part Finish 0.00

200

QC

Memo

0.00

Quality Control

5x 6 1/2 1/2 1/2 1/2

210 Identify as per dwg & Stock Location: _____ 0.00

210

Packaging

Memo

PPP 80707

0.00

Packaging

12/23/20 (5)

220 QC21- Final Inspection - Work Order Release 0.00

220

QC

Memo

0.00

Quality Control

MS 12/03/20

MS 12/03/20
(5)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 80708

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Parent Item: D2563

D2563

Parent Item Name: Step Weldment Assembly

Start Date: 27/02/2012

Required Date: 12/03/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:G 02.07.31 Re-format Location RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2244-116

Manufactured

No

100

Each

85.5000

1

5

D2244-116

Step Extrusion

**

12-03-01

Location

Loc Qty

Loc Code

HALL

85.5

60307

85.5

5

D2561

Manufactured

No

100

Each

24.0000

2

10

D2561

Lug

**

12-03-01

Location

Loc Qty

Loc Code

WA015

24

66813

5

74534

19

10

D2564

Manufactured

No

100

Each

26.0000

2

10

D2564

Mounting Angle

**

12-03-01

Location

Loc Qty

Loc Code

WA018

26

71591

26

10

D2673-34

Manufactured

No

100

Each

39.0000

1

5

D2673-34

End Plate

**

12-03-01

Location

Loc Qty

Loc Code

WA015

39

59690

20

69534

19

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D2563

D2563

Parent Item Name: Step Weldment Assembly

Start Date: 27/02/2012

Required Date: 12/03/2012

Start Qty: 5.00

Required Qty: 5.00

D2673-34

Manufactured No

150

Each

39.0000

1

5

**

12.03.12

D2673-34

End Plate

Location

Loc Qty

Loc Code

WA015

39

59690

20

69534

19

5

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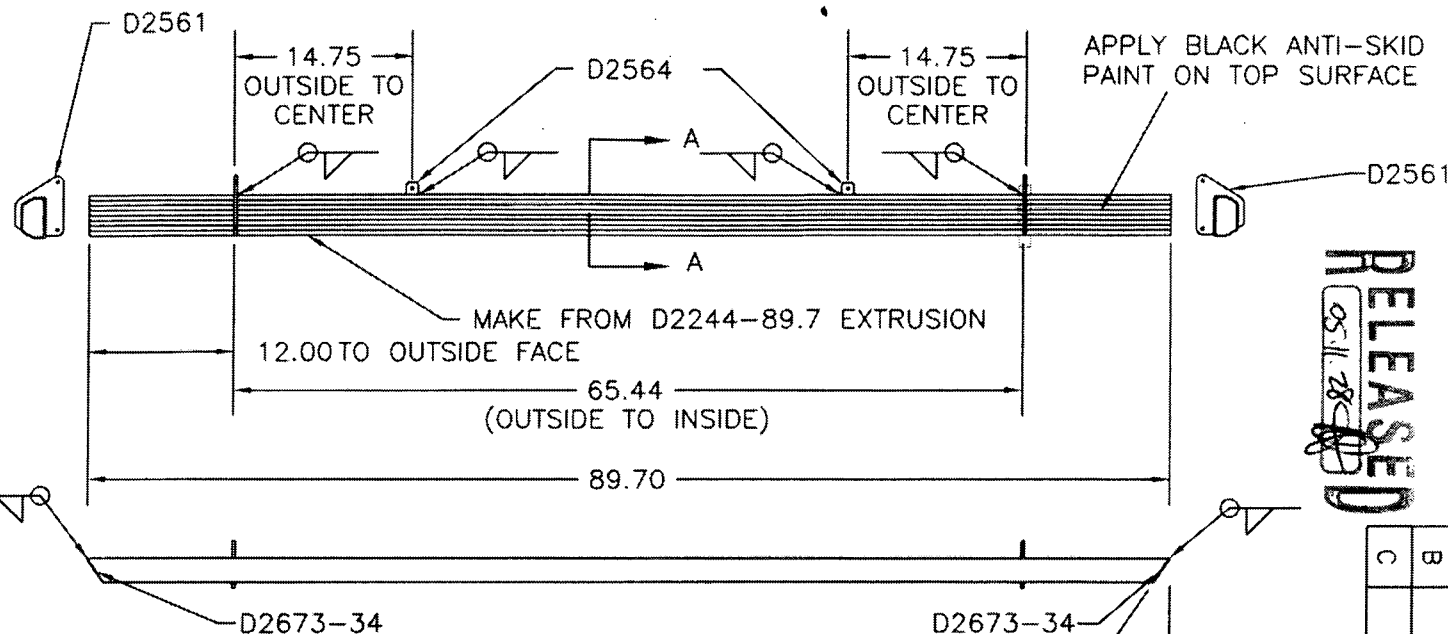
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RELEASED
05.11.28

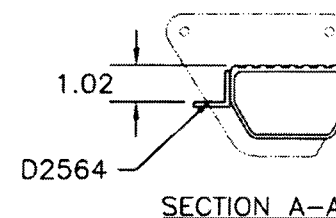
DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. C
BW	pt	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
		D2563	
DATE	TITLE	SCALE	
05.11.14	STEP WELDMENT ASSEMBLY	1:15	
A	96.04.26	NEW ISSUE	
B	97.05.14	END CAPS CHANGED (WAS D2248)	
C	05.11.14	UPDATE NOTES	



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing



D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

80708 MJS
12/02/27

W/O:		WORK ORDER CHANGES					
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